



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

004070

D350-591-213
Job Sheet 178934



Part No: D350-591-213

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible

JUN 25 2018



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/11/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E 10.11.15 update qty on AN4-11A DD verf:EC IPP REV:F 16.03.16 IIN REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/6/18	7/6/18	0.00	0.00	Start Up Stores/Pkg-2		JUN 25 2018
270	Packaging	1 pcs	7/6/18	7/6/18	0.00	0.00	Packaging1-3		
280	QC	1 pcs	7/6/18	7/6/18	0.00	0.00	QC4		
290	Packaging	1 pcs	7/6/18	7/6/18	0.00	0.00	Packaging3-1		
295	DC	1 pcs	7/6/18	7/6/18	0.00	0.00	DC		JUL 3 1 2018
300	QC21-FG	1 Ea	7/6/18	7/6/18	0.00	0.00	QC21		JUL 3 1 2018

Part Op 290 - Identify and pack for shipping as per PPP D350-591-213

Descriptions: 295 - Photocopy bluefile and type labels as per PPP D350-591-213 CHG005

FG039

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	2 Ea (2 ea)	90-Start up Operation	5067891
AN4-15A	Bolt	4 Ea (4 ea)	90-Start up Operation	5057424
AN5-36A	Bolt	2 Ea (2 ea)	90-Start up Operation	5068657
D2230-3	Mounting Lug	2 Ea (2 ea)	90-Start up Operation	5085080
D2618	Bushing	2 Ea (2 ea)	90-Start up Operation	5049859
D2732-030	Rubber Cushion (\$Per Foot)	1 Ea (1 ea)	90-Start up Operation	5073441
D3078-041	Step Assembly, Hi Short LH	1 Ea (1 ea)	90-Start up Operation	5092537
D3235-1	Mounting Lug	2 Ea (2 ea)	90-Start up Operation	5069974
D3338-1	Mounting Lug	1 Ea (1 ea)	90-Start up Operation	5080379
MS21042L3	Nut	2 Ea (2 ea)	90-Start up Operation	5078167
MS21042L4	Nut	6 Ea (6 ea)	90-Start up Operation	5067898
MS21042L5	Nut	2 Ea (2 ea)	90-Start up Operation	5058178
NAS1149D0363J	Washer	4 Ea (4 ea)	90-Start up Operation	5015269
NAS1149D0463J	Washer	12 Ea (12 ea)	90-Start up Operation	5067900
NAS1149D0563J	Washer	4 Ea (4 ea)	90-Start up Operation	5068662

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-35A	2	308	0
	AN4-15A	4	289	0

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	Rework Scrap Use-as-is	AGAINST DEPARTMENT/PROCESS	Skid-tube Machining Thermoforming Large Fab	Cross tube Small Fab Finishing Composite	Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier	Engineering Quality Other
Part No. _____							
NCR No. _____							

Date : _____ Step #: _____

Description Work Order D

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/25/18

DART
AEROSPACE
Container No: S084005
Part: D350-591-213
Job No: 178934
Serial No/Batch: S084005
Revision:
Inspector:
Exp Date:
Instructions:

Completed By _____
Lead hand / Supervisor _____
Approval Verification _____

QC / QA Coordinator _____
Approval _____

Root Cause		Environment		Design		Doc/Data		Equip/Tooling		Handling/Pre		Material		Internal Transport		Tribal Knowledge		Substation		Past Expiry Date		Misidentified	
☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
No Re-verification		Operator		Offset/Setup		Supplier		Training		Use for Testing		Poor Information		Rushing		Product Improvement		Process Improvement		Manufacturing Process		Past Due	
Centre Not Concentric		Cracks		Crimp/Kink/Ripple/Wave		Cuffs		Crushing		Heat Treat		Wave/Twist in Tube		Marks/Chatter		Broken/Unusable		Inspection Incomplete/Unqualified		Contamination		Countersink	
Out of Sequence		Off-set		Mislabeled		Fit/Function		Misaligned/off center		Positioned Wrong		Outside Dimensions		Over/Under tolerance		Part Incorrect		Part Lost/Missing		Part Moved		Drawing	
Finish		Misread		Turning Sequence																			

AN5-36A	2	302	0
D2230-3	2	20	0
D2618	2	148	0
D2732	1	363	0
D3078-041	1	10	0
D3235-1	2	246	0
D3338-1	1	29	0
MS21042L3	2	1,881	0
MS21042L4	6	2,959	0
MS21042L5	2	651	0
NAS1149D0363J	4	2,225	0
NAS1149D0463J	12	5,122	0
NAS1149D0563J	4	2,091	0

Part Specifications

Specifications could not be found.

Plex 6/11/18 10:36 AM Dart.lajeunesse.marie

Change Record

PAGE 1 OF 1

Part Number: D350-591-213/-213GB/-214/-214GB

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH/RH

[illegible]

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.